

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021130**Date Inspected:** 09-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Xu Xian Ping	<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>
<b>Inspected CWI report:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	
<b>Electrode to specification:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	
<b>Qualified Welders:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	
<b>Approved Drawings:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	
		<b>Delayed / Cancelled:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG Segment Assembly	

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

**Bay 6/CB 18**

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 3G position of weld joint CB3002J-001-045 located on CB 18. The welder is identified as 053609. ZPMC CWI is identified as Zheng Zhi Wei. The welding variables recorded by QC appeared to comply with the WPS B-T-2233-TC-U5-F. See attached photograph Pic\_001.

**Bay 7 /Steel Barrier W2-SB9**

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 2F position of weld joint W2-SB9-001-024 located on Steel Barrier W2-SB9. The welder is identified as 066163. ZPMC CWI is identified as Xu Hai Yang. The welding variables recorded by QC appeared to comply with the WPS B-T-2132-3.

**Bay 7/OBG Segment 14W**

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This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 2F position of weld joint DP3184-001-001 located on Deck Panel plate DP3480A to 'I' rib. The welder is identified as 204342. ZPMC CWI is identified as Xu Hai Yang. The welding variables recorded by QC appeared to comply with the WPS B-T-4132. See attached photograph Pic\_002.

Bay 8/OBG Bike Path

This QA inspector performed Magnetic Particle Testing (MT) approximately 15% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated MT report for this date. The member is identified as Steel Barriers as per ZPMC notification # 06901 items # 1, 5, 6, 7 and 8.

The weld designations reviewed are as follows:

Item # 1 BK004A6-055-055, 056, 059, 060, 104, 105, 106, 107, 108 and 109

Item # 2 BK004A6-055-013, 015, 016, 019, 020, 021, 031, 032, 029, 030, 041 and 042

Item # 3 BK004A6-055-117, 118, 033, 034, 043, 162, 045, 046, 047, 048, 049 and 163

Item # 4 BK004A8-055-013, 015, 016, 019, 020, 021, 022, 115, 116, 031, 032, 029, 030, 041 and 042

Item # 5 BK004A8-055-033, 034, 117, 118, 043, 044, 045, 046, 047, 048, 049, 050, 055, 056, 059, 060, 104, 105, 106, 107, 108 and 109



### Summary of Conversations:

No relevant conversations reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Gade,Ramesh

Quality Assurance Inspector

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**Reviewed By:** McClendon, Timothy

QA Reviewer